

Work Order ID 106335

\*106335\*

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August-28-13 3:19:49 PM

Item ID: D4915-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube Support  
 Start Date: 8/28/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 9/11/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: MLS Date: 13-08-28 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4915	A

100	Cut blanks as per folio	0.00							
*100*		0.00							
Bandsaw	Memo								
Jeaspa Bandsaw	CUT BLANK AT 7.125"								

110	HAAS CNC VERTICAL MACHINING #1	0.00							
*110*		0.00							
HAAS 1	Memo								
HAAS CNC vertical machine #1	1-Machine per folio FB207								
	DWG REV: <u>A</u>								
	FOLIO REV: <u>AA</u>								

2- deburr and break all sharp edges



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 Item Name: Skidtube Support  
 Start Date: 8/28/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 9/11/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		<i>CR 13/09/06</i>		<u>3</u>	<u>0</u>		
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		<i>S.A 13/09/07</i>		<u>3</u>	<u>0</u>		<i>DAS 08 08</i>
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i>  Memo	0.00  0.00				<u>3X</u>	<i>01 28</i>	<u>13-09-10</u>	

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Item ID: D4915-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube Support

Start Date: 8/28/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 9/11/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

13/9/11  
RB-09-11



# Picklist Print

August-28-13 3:19:53 PM

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Work Order ID: 106335

\*106335\*

Parent Item: D4915-1

\*D4915-1\*

Parent Item Name: Skidtube Support

Start Date: 8/28/13

Required Date: 9/11/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE JFS 13/08/28 VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB1750X6000 X4800		Purchased	No			100	f	0.0000	0.594	1.250526			

\*MUHMWB1750X6000X4800\*

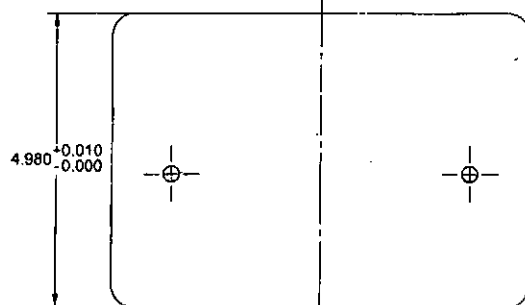
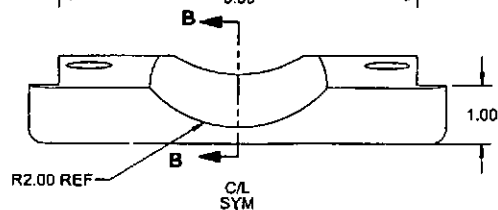
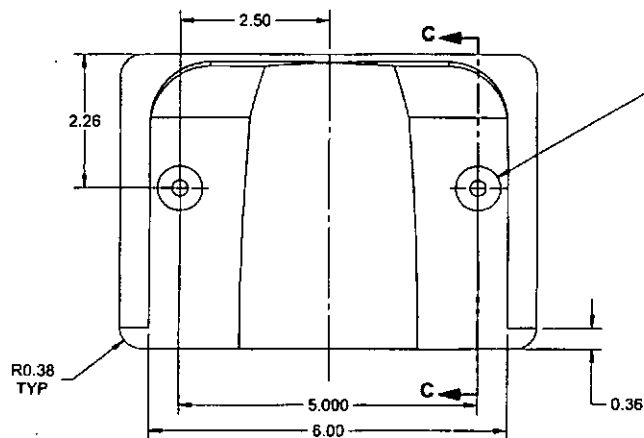
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UHMWB 1.750" X 6.000" X 48.000"

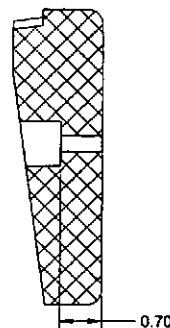
1126794 x 1.871 amk 13/09/16



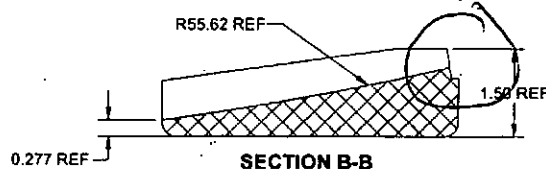




**D4915-1 SKIDTUBE SUPPORT**

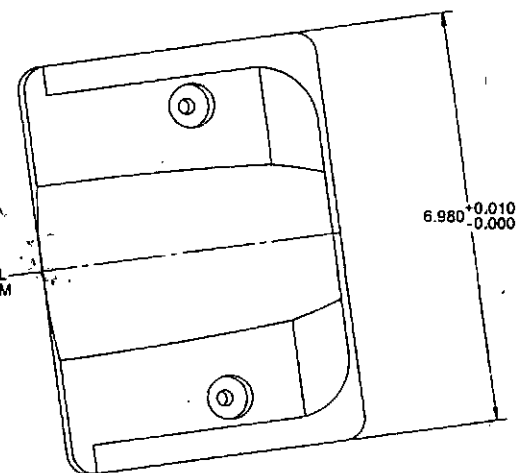


**SECTION C-C**

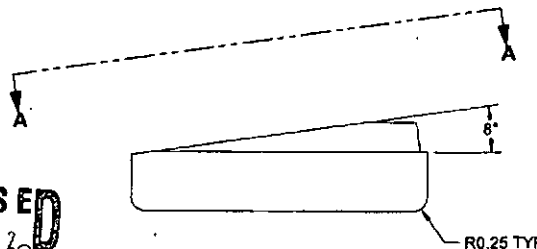


**SECTION B-B**

*No Draw  
Ahead*



**AUXILIARY VIEW A-A**



**RELEASED**  
2013-08-12

*10 6335 MJS  
13-08-28*

- NOTES:**
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.50 THICK, BLACK REF DART SPEC MUHMWB150
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.21 lbs
  - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL D4915-1-A.IGES

A NEW RELEASE		DB	13.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	<i>AS</i>		
MFG. APPR.	<i>AS</i>		
APPROVED	<i>AS</i>		
DE APPR.	<i>AS</i>		
DATE	13.07.22		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4915</b>	REV. A
TITLE <b>SKIDTUBE SUPPORT</b>	SCALE NTS

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DART AEROSPACE LTD		Work Order:	10633T
Description: SKIDTUBE SUPPORT		Part Number:	D4915-1
Inspection Dwg: D4915 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.980	$\pm .010$	4.980	—		Vern	M1-D6
1.00	$\pm .030$	1.003	—		"	
6.00	$\pm .030$	5.995	—		"	
5.000	$\pm .005$	5.005	—		"	
R.38	$\pm .030$	R.380	—		R-G	
2.26	$\pm .030$	2.258	—		Vern	M1-D6
.36	$\pm .030$	.350	—		"	
$\phi .266$	$\pm .004$	$\phi .265$	—		"	
$\phi .750$	$\pm .010$	$\phi .750$	—		"	
.70	$\pm .030$	.700	—		"	
.277	$\pm .010$	.282			"	
1.50	$\pm .030$	1.500	—		"	
6.980	$\pm .010$	6.980	—		"	
R.25	$\pm .030$	R.250	—		R-G	
8°	$\pm 1/2^\circ$	8°	✓		C-Square	

Measured by: <i>[Signature]</i>	Audited by: D.A. DAS	Preliminary Approval:
Date: 13/09/06	Date: 13/09/08	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

